

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014088**Date Inspected:** 16-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #13--OBG 13A section mock up

Caltrans QA Inspector observed eight welders performed FCAW PJP weld process on eight pieces interior stiffeners with 45mm wall thick that connected bottom plate of OBG 13A mock up deck section. The interior stiffeners ID are X3472C(FS), X3472G(FS0, X3471C(NS), X3472G(NS), X3472J, X3472G, X3472A and X3472B. The minimum preheat and maximum interpass temperature requirements for FCAW PJP weld are 160C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA Inspector observed a welder performed FCAW PJP weld process on one of East line lift eye path. The lift eye path is attached to side plate and bottom plate. The minimum preheat and maximum interpass temperature requirements for FCAW CJP weld are 180C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed a welder and a grinder performed carbon arc back gouging process on one of the lift eye path of East line side. Approximately 10mm sound wall thick has been gouged out. The back gouging area has been re-bevel to request design joint by grinding and the beveled surface is entirely free of the scale, traces of oxide films and other contaminants prior welding. Base on Caltrans observation, no discrepancies were noted.

CLOSING STATEMENT

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

documents.

Summary of Conversations:

As notes within report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Deyer 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
